



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2348

Job Sheet 178550



Part No: D2348

Job Qty: 24 ea

Part Name: Wearplate (Key Way)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 6/26/18 **6/29**

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev A Removed from 9 Digit 05-12-05 JLM IPP Rev:B Now on Waterjet 06-07-03 JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		6/26/18	0.00	0.00	Start Up Waterjet		2 18/6/19
100	Waterjet	24 pcs		6/26/18	0.01	0.89	Waterjet1		2 18/6/19
120	QC	24 pcs		6/26/18	0.00	0.00	QC8		38
150	Outsource	24 pcs		6/26/18			ATG001-VC	5	CR 18-6-21
160	Packaging	24 pcs		6/26/18	0.00	0.00	Packaging2		38 18.06.29
170	QC	24 pcs		6/26/18	0.00	0.00	QC5		38
180	Small Fab	24 pcs		6/26/18	0.00	0.65	Small Fab		38 9-89
190	QC	24 pcs		6/26/18	0.00	0.00	QC5		38
200	Packaging	24 pcs		6/26/18	0.00	0.00	Packaging3		38 13 2018
210	QC21-SA	24 Ea		6/26/18	0.00	0.00	QC21		53 JUL 16 2018

Part Op 100 - 1-Cut as per Dwg D2348

Descriptions: 150 - Issue P/O: **040283** Black Anodize per Dwg D2348 Rev. C

160 - Ensure certificate of conformity is attached

170 - INSPECT CERTS

180 - Install Insert as per Dwg D2348

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.4752 sf (.0198 ea)	90-Start up Operation	
D3996-FE-832-EF	Self-Clinching Fastener	96 Ea (4 ea)	180-Small Fab	5076006

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	0	347	0
180-Small Fab	D3996-FE-832-EF	96	38	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240	0.252	
2	Wear Plate	0.648Inches $\pm$ 0.010	0.658 0.638	0.650	
3	Wear Plate	0.795Inches $\pm$ 0.005	0.800	0.798	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐		Water Jet ☐ Prod Eng Coord. ☐ Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Engineering ☐ Quality ☐ Other ☐ 42) Approval _____ Initialed By _____ 1 / Supervisor _____ 1 Verification _____ Coordinator approval _____ Container No: S082433 Part: D2348 Job No: 178550 Serial No/Batch: S082433 Date: 06/19/18																																																									
Date :		Step #:		Description Work Order Deviation 																																																											
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> </tr> </thead> <tbody> <tr> <td style="width: 15%;">Environment</td> <td style="width: 10%;">☐</td> <td style="width: 15%;">No Re-verification</td> <td style="width: 10%;">☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> </tr> <tr> <td colspan="4" style="text-align: left; padding: 5px;">OTHER : _____</td> </tr> </tbody> </table>								Root Cause				Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	OTHER : _____			
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			0.790	
4	Wear Plate	2.046Inches $\pm$ 0.010	2.056 2.036	2,046
5	Wear Plate	1.295Inches $\pm$ 0.010	1.305 1.285	1,299
6	Wear Plate	0.656Inches $\begin{matrix} + 0.005 \\ - 0.000 \end{matrix}$	0.661 0.656	0,656 Diameter
7	Wear Plate	0.290Inches $\begin{matrix} + 0.003 \\ - 0.000 \end{matrix}$	0.293 0.290	0,290 Diameter
8	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240	0,252 Diameter
9	Wear Plate	0.250Inches $\pm$ 0.010	0.260 0.240	0,251
10	Wear Plate	0.648Inches $\pm$ 0.010	0.658 0.638	0,650
11	Wear Plate	1.546Inches $\pm$ 0.005	1.551 1.541	1,550

Plex 6/1/18 1:46 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040283**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040283
PO Date: 6/21/18
Due Date: 6/29/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
①	178550	D2348	Wearplate (Key Way) Issue P/O: _____ Black Anodize per Dwg D2348 Rev. C	Firmed	6/29/18	24 pcs	0 pcs 24x	24 pcs	\$6.57/pcs	\$157.68
②	179160	646.3717	Doubler Issue P/O _____ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	6/29/18	12 pcs	0 pcs 12x	12 pcs	\$8.67/pcs	\$104.04
③	179159	646.3715	Strut Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	6/29/18	20 pcs	0 pcs 20x	20 pcs	\$8.67/pcs	\$173.40
④	178822	RBW6505G00831-3G-25	Mount Plate -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant AS PER DWG RBW6505G00831-3G-25 REV. 2	Firmed	6/29/18	6 pcs	0 pcs x6	6 pcs	\$6.57/pcs	\$39.42

Grand Total: \$474.54

Order Notes



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915474

Date: 28-Jun-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
24 ea	Part: D2348 Wearplate (Key Way) Anodize per MIL-A-8625F, Type II, Class 2, Black, .0004-.0010" (.4 - 1 mils) Job: 23341	Rev: C	PO: PO040283 Line: 1
12 ea	Part: 646.3717 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23342	Rev: A	PO: PO040283 Line: 2
20 ea	Part: 646.3715 Strut Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23343	Rev: A	PO: PO040283 Line: 3
6 ea	Part: RBW6505G00831-3G-25 Mount Plate Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 23344	Rev: 2	PO: PO040283 Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>28/6/18</u> Certified Signature: _____ Receiver Signature: _____ Made in Canada.			

